

Date: Tuesday, 5/27/2008 2:31:48 PM  
 User: Chantal Lavoie

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG EXTRUSION  
 Job Number : 39513  
 Estimate Number : 10305  
 P.O. Number :  
 This Issue : 5/27/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D2423  
 Drawing Number : D2423 REV B1  
 Project Number : N/A  
 First Issue : 5/27/2008 Type : PURCHASED PARTS Drawing Revision : B1  
 Previous Run : 33310 Material :  
 Due Date : 6/16/2008 Qty: 549 Um: Each  
 Written By :  
 Checked & Approved By :  
 Comment : Est G 04.09.02 Part Number D2423-108 changed to D2423KJ/J LM

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
2.0	D2423P	Lug Extrusion
Comment: Qty.: 1.0000 f(s)/Unit Total : 549.0000 f(s) Lug Extrusion <i>P/D 6455 C 08/05/29 (549) FT</i> <i>08/06/13 567 PIR O</i> <i>08/06/13</i> <i>08/06/13 Dm 2</i> <i>08/06/16</i>		
3.0	PACKAGING 1	PACKAGING RESOURCE #1
4.0	QC6	DIMENSIONAL CHECK
5.0	PACKAGING 1	PACKAGING RESOURCE #1
6.0	QC21	FINAL INSPECTION/W/O RELEASE
Comment: FINAL INSPECTION/W/O RELEASE <i>08/06/16</i>		

Job Completion



*4 08-26-16*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

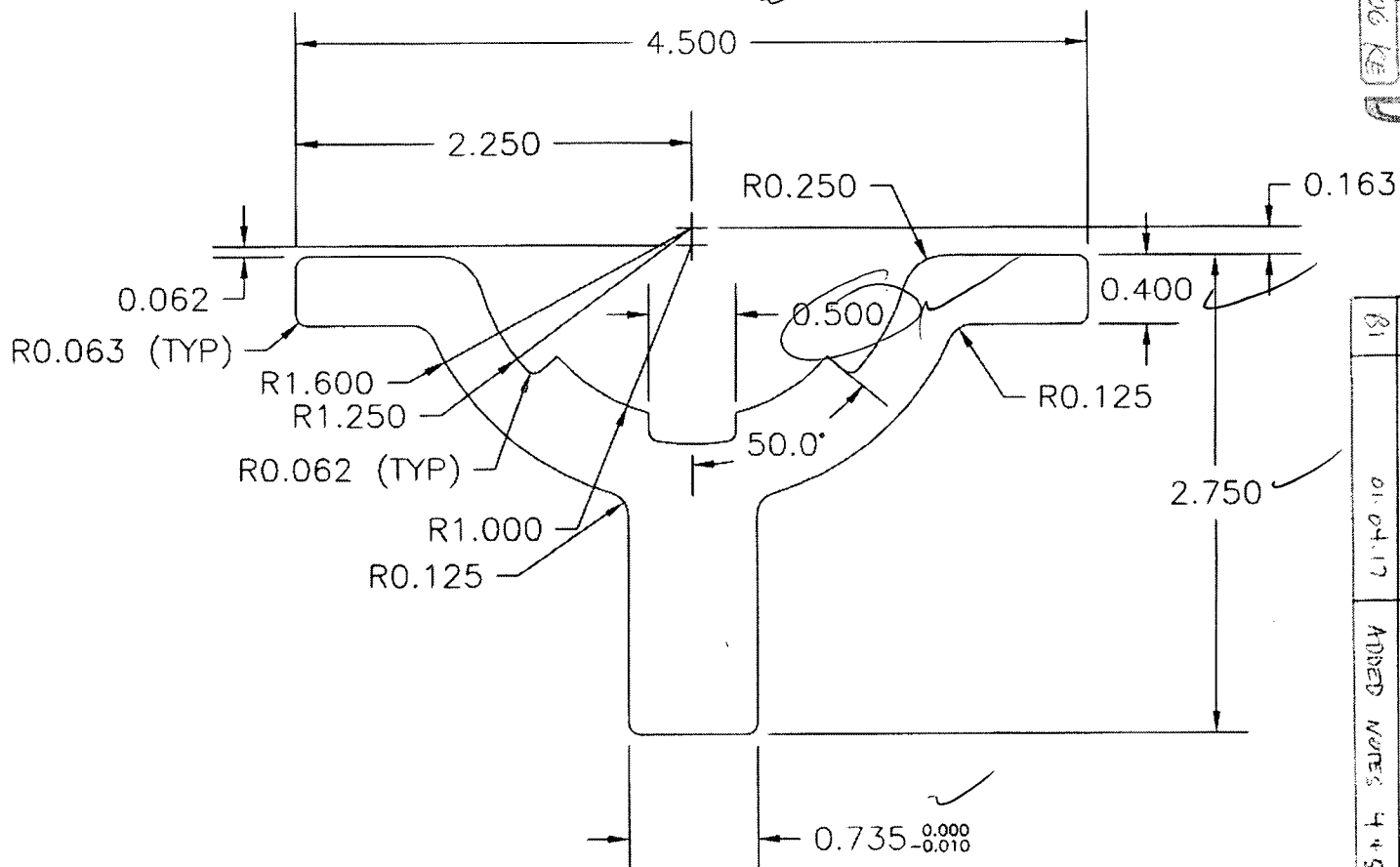
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



RELEASED  
93/08/06 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
4E	4E	DRAWING NO.	REV. B
CHECKED [Signature]	APPROVED [Signature]	D2423	SHEET 1 OF 1
DATE 98.08.04	TITLE LUG EXTRUSION	SCALE 1:1	
A	95.05.09	NEW ISSUE	
B	98.08.04	6061-T6 WAS 6005A.15	
81	01.04.17	ADDED NOTES 4+5	



- 1 MATERIAL: 6061-T6 ALUMINUM (QQ-A-200/8)
- 2 NOTE: ALL DIMENSIONS ARE IN INCHES
- 3 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4 MANUFACTURED USING CAMADON INDIALEX DIE # MS-12806
5. PART NUMBER IS D2423-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2423-108 IS 108" LONG)

**FEUILLE D'EMPAQUETAGE**  
**PACKING SLIP**

# DART

## Purchase Order

Date May 28, 2008	Page 1
Purchase Order Number PO00006455	

Dart Aerospace Ltd  
1270 Aberdeen St  
Hawksbury, Ontario K6A 1K7  
Phone: (613)632-9577  
Fax: (613)632-1053

*REVISED*

**Vendor Address:**

Indalex Limitee  
325 Rue Avro  
Pointe-Claire, QC H9R 5W3  
Canada  
Phone (514) 697-5120  
Fax (514) 694-8310

**Ship To:**

Main Finished Goods Location  
Dart Aerospace Ltd  
1270 Aberdeen St  
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VC-IND006	May 28, 2008	N30	yours	Jun 16, 2008

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
549.0000	D2423P	Lug Extrusion <i>NEW 567 P100</i> Comments: AS PER DWG D2423 REV. B1 MATERIAL: 6061-T6 (QQ-A-200/8) MANUFACTURE USING CARADON INDALEX DIE # MS-13866 B39513	6/16/2008	No	11.074681	f	6,080.00
<div>MATERIAL CERTIFICATION REQ'D UPON DELIVERY</div>							
Comments: <i>REVISED.</i>		Tax Summary:		Less:			
		GST		304.00			
		GSTME		0.00		included tax	
		GSTND		0.00			
Entered By: <i>CL</i> CLAVOIE		Approved By: _____		Subtotal		6,080.00	
				Total tax		304.00	
				Total purchase order in			
				CAD Dollars		6,384.00	



325 rue Avro  
Pointe-Claire QC H9R 5W3

Téléphone (514) 697-5120  
Fac-simile (514) 694-8310

## Rapport des propriétés mécaniques Mechanical Properties Test Report

Client / Customer : **DART AEROSPACE LTD**  
 Adresse / Address : **1270 ABERDEEN STREET  
HAWKESBURY ONT,  
K6A 1K7**  
 # commande Indalex / Indalex order # : **8080497**  
 # bon de commande / Purchase order # : **6455**  
 # de matrice / Die # : **MS 18886** Description: **LUG EXTRUSION**  
 Alliage & trempage / Alloy & temper : **6061 T6**  
 # Contrôle / Control # : **76487-1**  
 # Coulée / Cast # : **43572**

	Min.requis Min.required	Résultat actuel Actual results
Tension ultime Ultimate stress (psi)	38 000	38269
Contrainte élastique Yield stress (psi)	35 000	35349
% elongation dans 2" % elongation in 2"	8	12
Dureté Rockwell E (hrs) Rockwell E Hardness (hrs)	88 @ 100	90

### Composition chimique typique / Typical chemical composition :

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti
6063	0.20 - 0.60	0.35 Max	0.10 Max	0.10 Max	0.45 - 0.90	0.10 Max	0.10 Max	0.10 Max
6005	0.60 - 0.90	0.35 Max	0.10 Max	0.10 Max	0.40 - 0.60	0.10 Max	0.10 Max	0.10 Max
6005A	0.68 - 0.72	0.15 - 0.27	0.08 - 0.12	0.20 - 0.24	0.48 - 0.52	0.03 Max	0.05 Max	0.03 Max
6061	0.40 - 0.80	0.70 Max	0.15 - 0.40	0.15 Max	0.80 - 1.20	0.04 - 0.35	0.25 Max	0.15 Max
6351	0.7 - 1.3	0.5 Max	0.10 Max	0.40 - 0.80	0.40 - 0.80	—	0.20 Max	0.20 Max

Nous certifions que le matériel fourni rencontre les exigences chimiques telles qu'annoncées par la norme ASTM B-221 excepté pour la section 8.2 (nombre de spécimen) et AMS QQA 200/8 excepté pour la section 4.2.3.1 (nombre de spécimen) qui sont déterminés par les exigences du client.

We hereby certify that the material supplied meets the chemical properties as published by the ASTM B-221 except for section 8.2 (number of specimen) and AMS QQA 200/8 except for section 4.2.3.1 (number of specimen) which is determined by customer requirement.

Sincèrement vôtre,  
Yours truly,

date : 2008-06-10

*Patrick Bader*

Patrick-Martin Bader  
Technicien de la qualité  
Quality technician

Indalex Limited